

Work Order ID 70936

Monday, June 20, 2011 8:26:01 AM



Page 1

Item ID: D206-642-341

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 6/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: PDate: 6/20/2011

Tooling:

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2650

F

0.00

100



DOCUMENT CONTROL

0.00

DC

Memo

Document Control

Photocopy bluefile and create labels per PPP D206-642-341 CHG003

N/A tg

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Deburr Fwd edge of tube								
	2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650								
	3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.								
	A/R <input type="checkbox"/> Aluminum Rod <input checked="" type="checkbox"/> M112860/M117456								
	4-Grind weld flush to cap on top surface only.								
	5-Cut aft end to length as per dwg D2650								
	6-Drill pilot holes using drill Jig DT8168A (A, & B) and DT8025. Open to Ø0.312"								
	7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".								
	8-Open Aft Cap Hole using #6 Drill Bit								
	9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail								
	10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650								
	11-Deburr and Blow out all chips from inside the tube								

3 OK 11/06/20

BE 11/06/20

BE 11/06/20

BB

11/06/28

W/O:		WORK ORDER CHANGES					
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

115

QC5- Inspect part completeness to step on W/O

0.00



0.00 Silae/28

QC

Memo

Quality Control



120

Chemical Conversion Coat per QSI005 4.1

0.00



0.00 1/Ae 11.06.28.

HandFinish

Memo

Hand Finishing

125

QC3- Inspect Part Finish

0.00



0.00

QC

Memo

Quality Control

1 0 BE11/06/28

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-5 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting

Start Date: 11/06/28 Time: 4:10

Finish Date: 11/06/29 Time: 4:00

A/R: Sikaflex-291 M116954

Sikaflex expiry date: 12/01/15

DR 11/06/28

B 11/06/28

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1 0 BE 11/06/29

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Required Date: 7/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
A/R ☐ Aluminum Rod M112860 BE 11/06/09

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube BB 11/07/04

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Debur BE 11/07/04

4- Install nut plate as per dwg BB 11/07/04

170

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

S 11/07/04

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 ulozlay

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

IX ~~Ø~~ M/L 11/07/06

205

0.00



SprayPaint

Memo

0.00

Spray Painting

PRIME B 117319
DEFLEET BLUE B 115985
DEFLEET CLEAR B 117113

8T 11 - 07 - 12

W/O:		WORK ORDER CHANGES					
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Work Order ID 70936

Monday, June 20, 2011 8:26:02 AM



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Setup Start



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Item Name: Replacement Skidtube

Start Date: 6/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

215

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

MA 11-07-13 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	HandFinishing	0.00							
	Hand Finish								
Hand Finishing	<p>Memo</p> <p>1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. <input checked="" type="checkbox"/> A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> <u>1116040</u> Sikaflex expiry date: <input type="checkbox"/> <u>15/06</u></p> <p>2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive</p> <p>3-Install MS27039-4-06 Screw as per DEO 9153</p> <p>4-Inspect for foreign object per QSI 024</p> <p>5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive <input checked="" type="checkbox"/> A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> <u>1116040</u> Sikaflex expiry date: <input type="checkbox"/> <u>15/06</u></p> <p>6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4 Batch: <u>1117663</u></p>	0.00							
						1	0	1110714	

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

S. W. 10/14

Quality Control

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

S. W. 10/14

Quality Control

250

Packaging

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPP D206-642-341

Location: _____

PPP Rev: *PPP 69962*

Packaging

Rec'd 7/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/14

MF 11-07-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Monday, June 20, 2011 8:26:08 AM

Page 1

Work Order ID: 70936

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube



Start Date: 6/20/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
 IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960JD416	NAS1149D0463J	Purchased	No				Each	0.0000		1			
Washer								1117591					

CCR264SS3-3		Purchased	No				Each	569.0000		2			
Cherry Rivet													

Location	Loc Qty	Loc Code
FP-B	2	
113973	2	
ST311	567	
117086	71	
117849	496	

CR3212-4-03		Purchased	No				Each	1,216.000		2			
Cherry Rivet													

Location	Loc Qty	Loc Code
FP-B	2	
110139	2	
ST311	1214	
114859	1214	

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Work Order ID: 70936

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 6/20/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

D2620

Manufactured No

Each

12.0000

1



Skidtube, 206 Skidtube

Location

Loc Qty

Loc Code

LG

12

62684

1

68135

1

68136

10

D2647

Manufactured No

Each

25.0000

1



Cap

Location

Loc Qty

Loc Code

LG002

25

55352

25

D2649

Manufactured No

Each

111.0000

19



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

99

68224

2

70394

97

LG001

12

65317

1

68507

11

D2654-5

Manufactured No

Each

3.0000

1



Web

Location

Loc Qty

Loc Code

LG

3

70229

3

71309

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Shop Packet Print

W/O:		WORK ORDER CHANGES					
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Start Date: 6/20/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

D2680-041 Manufactured No

Each 30.0000



Nut Plate

Location

Loc Qty

Loc Code

ST020

30

55366

17

70088

13

MS27039C1-08 Purchased No

Each 804.0000



SCREW

Location

Loc Qty

Loc Code

FP-A

1

116022

1

ST293

803

116373

3

117291

800

ALS4-1032-130 Purchased No

220 Each 1,498.000



Insert

Location

Loc Qty

Loc Code

ST281

8

117331

8

ST282

1490

117717

1490

AN960C10L NAS1149C0332 Purchased No

220 Each 0.0000



washer

AN960JD10L NAS1149D0332L Purchased No

220 Each 0.0000



Washer

1
① JB 11/07/04

56
MU 11/07/04

54
X56
MU 11/07/04

54
X54
M 11/03/06
(x54) 11/07/14

2
(x2) 11/07/14

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Shop Packet Print

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Start Date: 6/20/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

220

Each

82.0000

1

1



Aft Cap



JL 1107114

LocationLoc QtyLoc Code

FP004

62

B71038

x1

68280

62

FP006

20

62678

20

D2651-1

Manufactured No

220

Each

251.0000

14

14



Plug



JL 1107114

LocationLoc QtyLoc Code

fpa

109

69018

109

FP-A

142

B70942

x14

57869

1

66445

10

67760

97

70827

30

70839

4

D2651-3

Manufactured No

220

Each

536.0000

14

14



O-Ring



JL 1107114

LocationLoc QtyLoc Code

FP-A

536

61962

104

66956

432

x14

Monday, June 20, 2011 8:26:10 AM

Shop Packet Print

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 20, 2011 8:26:10 AM

Work Order ID: 70936

Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 6/20/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00



D3535-11	Manufactured	No	220	Each	8.0000	1	1
							<u>21 210714</u>

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP019	8	
-------	---	--

<u>68362</u>	8	
--------------	---	--

D3535-23	Manufactured	No	220	Each	20.0000	1	1
							<u>21 210714</u>

Wearshoe



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP021	20	
-------	----	--

66236	-1	
-------	----	--

67594	8	
-------	---	--

<u>68342</u>	13	
--------------	----	--

D3535-35	Manufactured	No	220	Each	30.0000	1	1
							<u>21 210714</u>

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP018	10	
-------	----	--

65926	1	
-------	---	--

67598	1	
-------	---	--

68348	8	
-------	---	--

ST	20	
----	----	--

<u>69756</u>	20	
--------------	----	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 20, 2011 8:26:10 AM

Work Order ID: 70936

Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 6/20/2011

Required Date: 7/15/2011



Start Qty: 1.00

Required Qty: 1.00

D3536-11	Manufactured	No	220	Each	13.0000	1	1
							<u>xl 1107111</u>



Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP011	13	B71283
46649	1	<u>xl</u>
46715	4	
65574	8	

D3536-23	Manufactured	No	220	Each	39.0000	1	1
							<u>xl 1107114</u>



Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP011	39	
43406	1	
66560	12	
69902	26	<u>xl</u>

D3536-35	Manufactured	No	220	Each	27.0000	1	1
							<u>xl 1107114</u>

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP012	27	
67599	1	
69755	26	<u>xl</u>

D3537-1	Manufactured	No	220	Each	10.0000	6	6
							<u>xl 1107114</u>

Wearpad

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP017	10	
69817	10	B70686
		<u>x6</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, June 20, 2011 8:26:10 AM

Page 7

Work Order ID: 70936

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 6/20/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-3

Manufactured No

220 Each

9.0000

1

1



20 11/07/14

Wearpad

Location

Loc Qty

Loc Code

FP017

1

B70817

35697

1

21

FP19

8

69292

8

MS27039-4-06

Purchased No

220 Each

57.0000

1

1



21 11/02/14

Screw

Location

Loc Qty

Loc Code

FP-A

23

115460

23

21

ST292

34

115460

34

Monday, June 20, 2011 8:26:10 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70934
PL 11-06-20

RELEASED
08-07-23

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG CW D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2650	SHEET 1 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206/407 SKIDTUBE ASSEMBLIES	NTS
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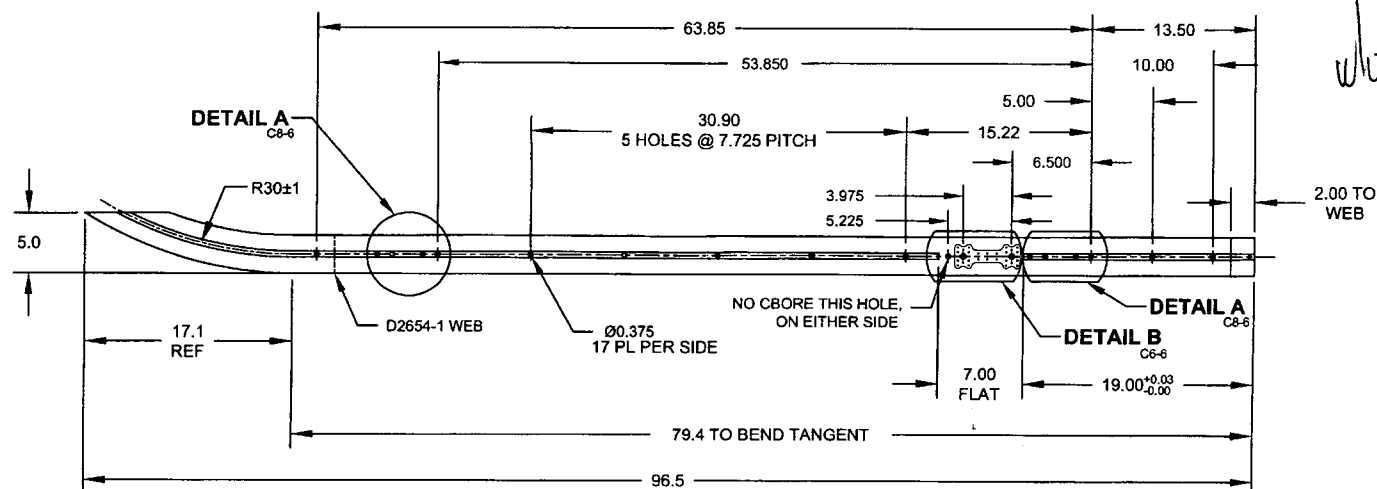
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

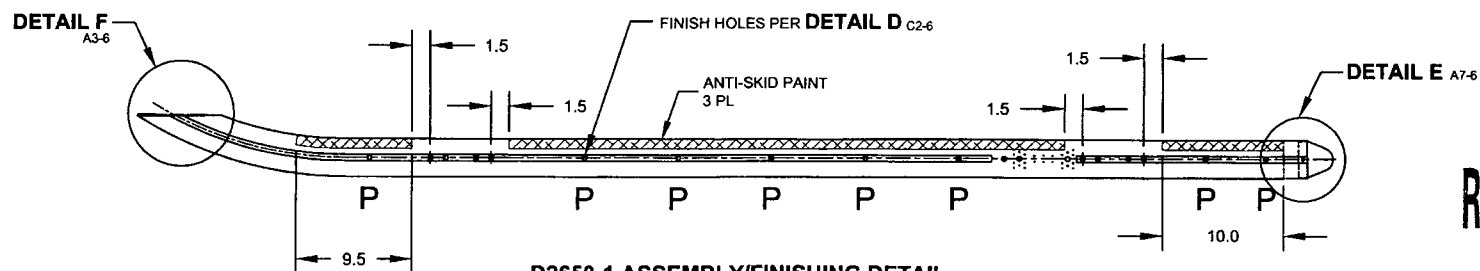
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-1 BENDING/DRILLING DETAIL



D2650-1 ASSEMBLY/FINISHING DETAIL

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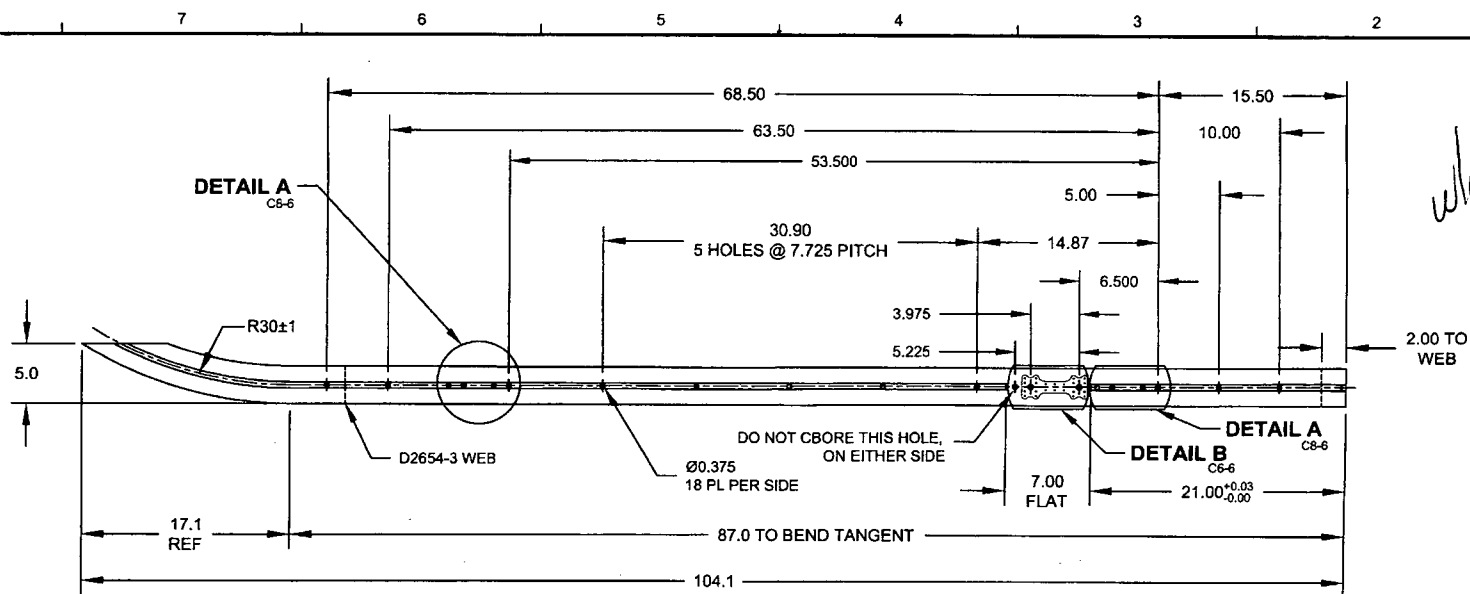
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

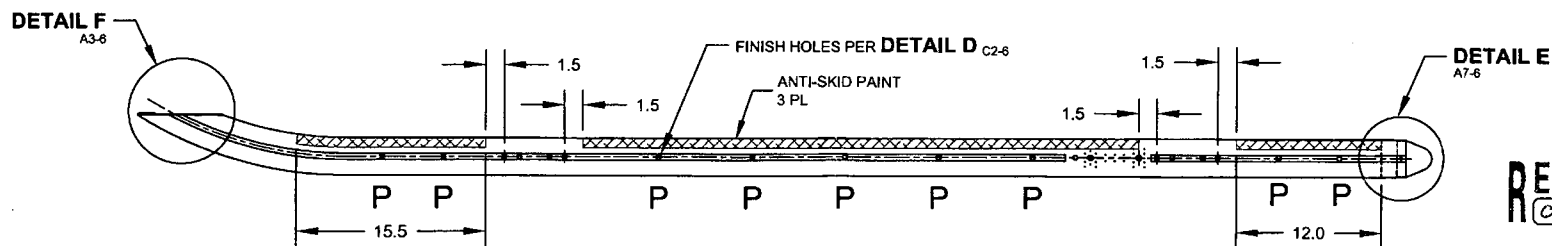
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			





NOTE: Date & initial all entries



D2650-3 BENDING/DRILLING DETAIL



D2650-3 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
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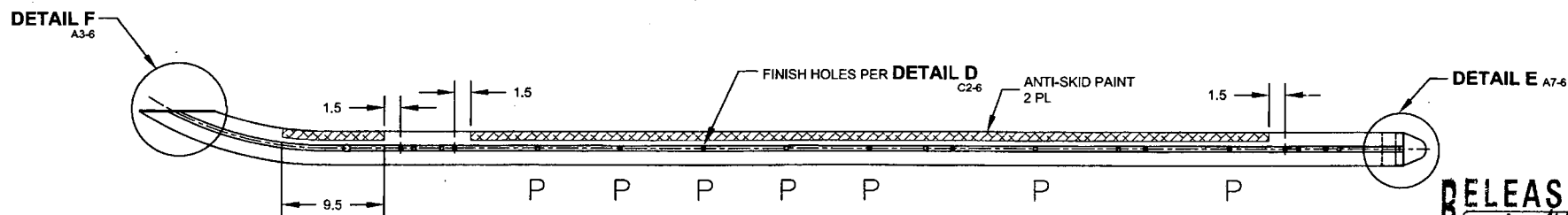
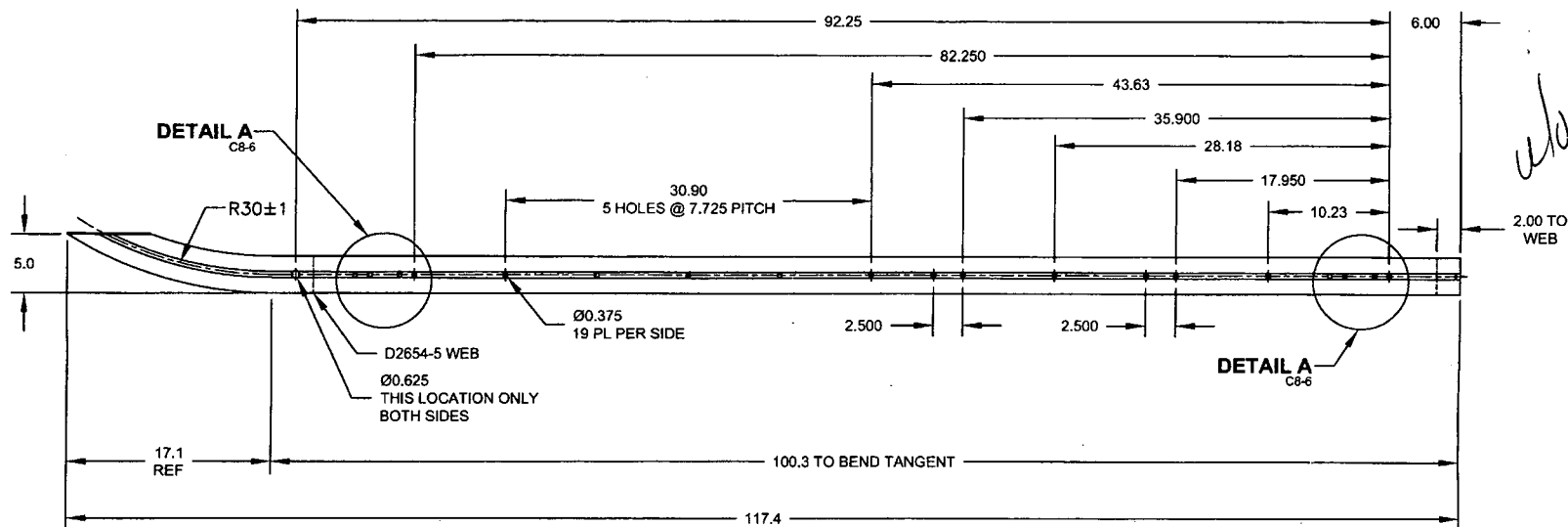
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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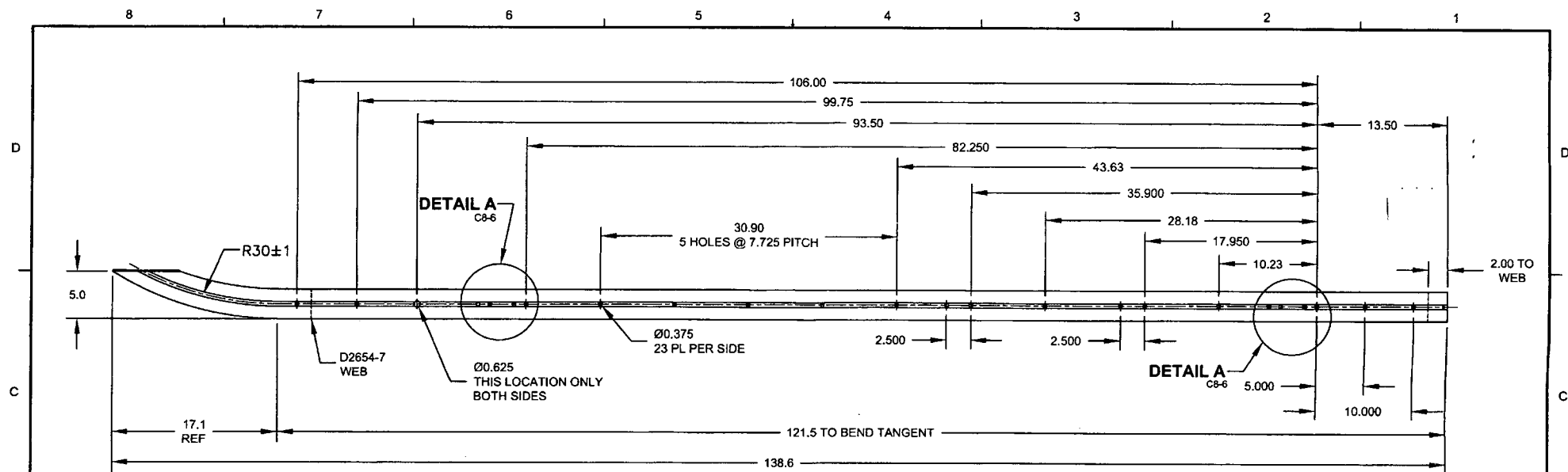
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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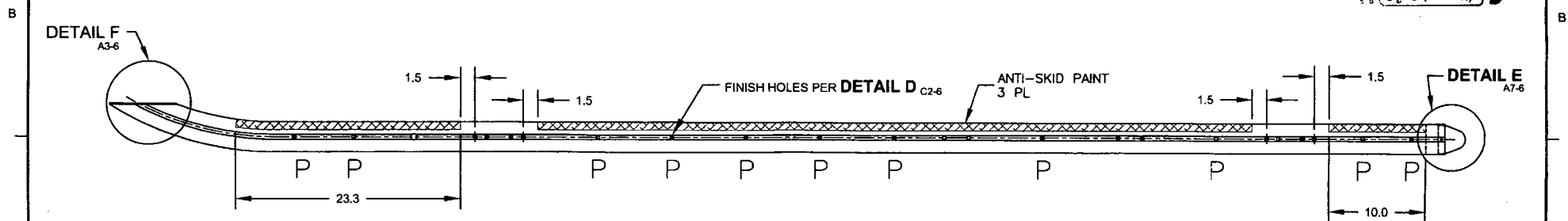
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W/10034



D2650-7 BENDING/DRILL DETAIL

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02 07 22 1977



D2650-7 ASSEMBLY/FINISHING DETAIL

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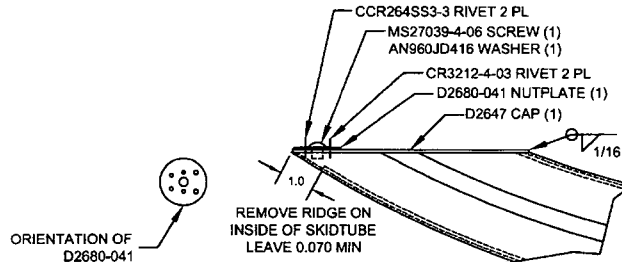
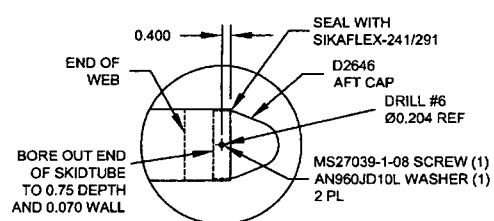
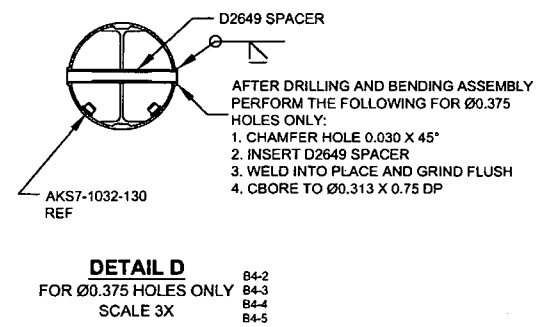
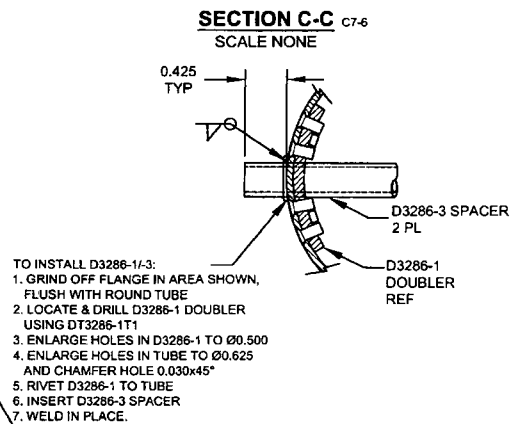
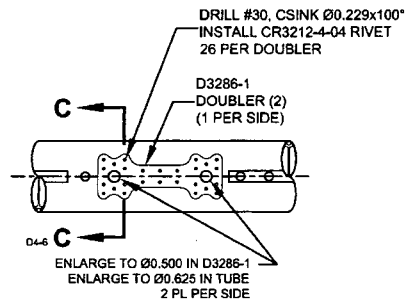
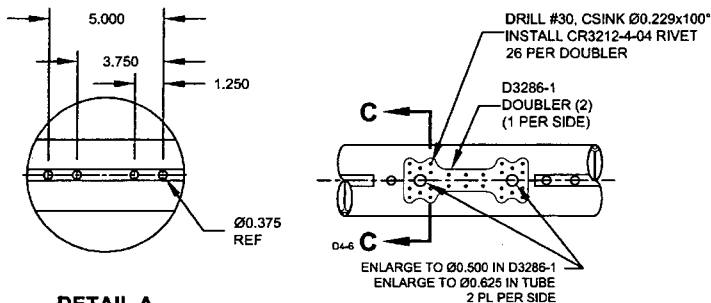
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NOTE: Date & initial all entries



DETAIL F NOTES:
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR
TO FINISH

RELEASED
05-09-2019

DESIGN	DS	DART AEROSPACE USA, INC	
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 255
~~255~~

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 69953
Part number: 3206-642-341
Description: 206
Welding Process: Tig ☒ Mig ☐
Base material: _____
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pat Cunn Date of Test Coupon 11.06.14
Welder Barclay Elliot Date of Test Coupon 11/06/14

The above named individual is qualified in accordance with AWS D17.1.2001 to weld